

Work Order ID 56147

February 11, 2010 12:07:28 PM

Page 1

Item ID: D3186-1

Revision ID:

Item Name: Spacepod Door, LH

Start Date: 2/11/10 Start Qty: 1.00

Required Date: 2/19/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: 

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3186

Rev E

100

0.00



Small Fab

Small Fab

Memo

0.00

repair holes drilled for side opening per
QSI 006
indicate all parts & B/N taken for repair:

PTO

8 10-02-18

1-Drill holes and cut out latch slots per dwg D3186 (D3186-1 detail)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 02/12

40

W/O: 56147		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-02-18	100	For RE re-work performed on D3186-1 apocast 50-A1 m 112935 cloth 902 FG 778150-550 Rol m 111166 Hysol 934 m 113022 milled fibre m 100859	BT	10-02-18			S 10/02/18

Part No: D3186-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56147

February 11, 2010 12:07:29 PM

Page 2

Item ID: D3186-1

Accept

Revision ID:

Item Name: Spacepod Door, LH

Start Date: 2/11/10 Start Qty: 1.00

Required Date: 2/19/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

composites

RT

10-02-18

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/23
MF
10-2-18

Picklist Print

February 11, 2010 11:38:19 AM

Page 1

Work Order ID: 56147



Parent Item: D3186-1



Parent Item Name: Spacepod Door, LH

Start Date: 2/11/10

Required Date: 2/19/10

Comments: IPP Rev:A New Issue 05-11-29 JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3186-1	PM	Purchased	No				Each	3.0000	1.0000			
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Spacepod Door



85

10-02-18

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

CA

3

53188

1

53189

1

53633

1

81

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

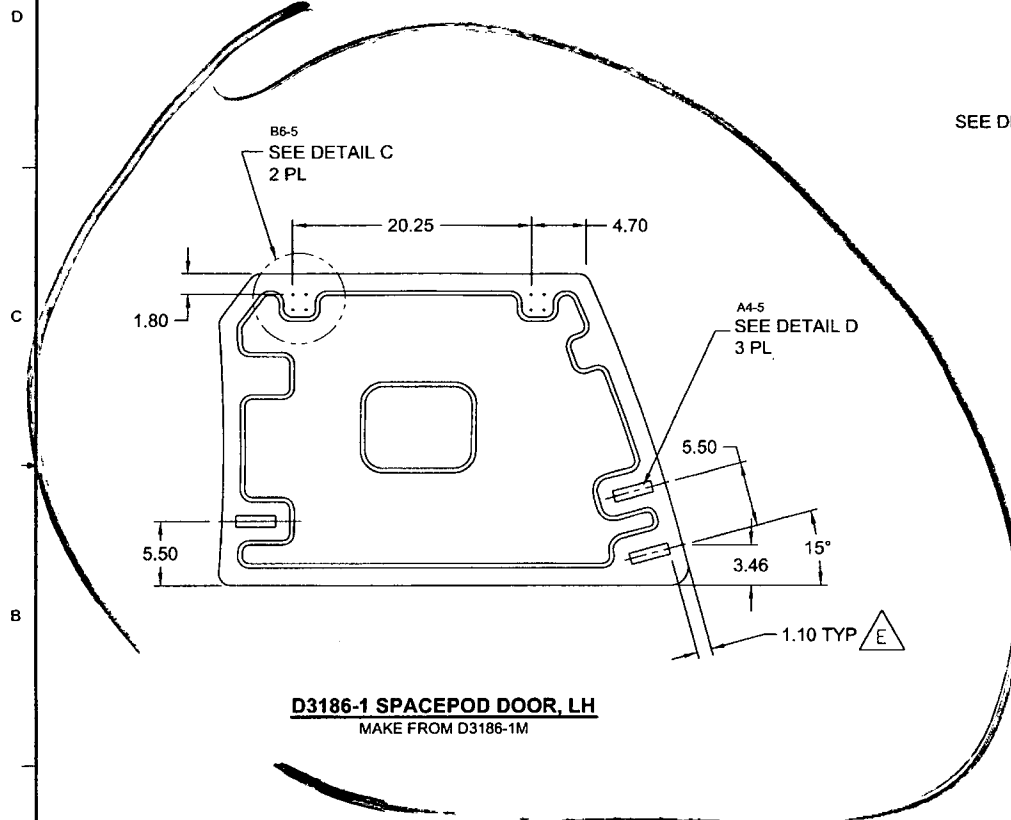
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

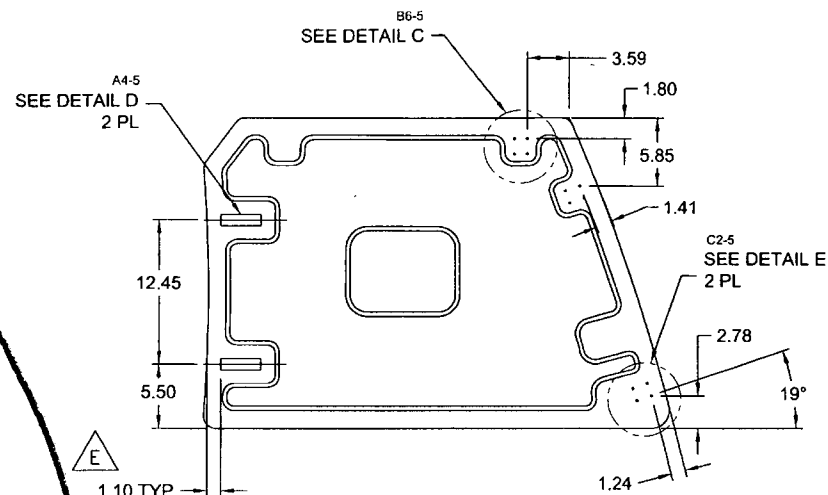
8 7 6 5 4 3 2 1



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

REV.	DESCRIPTION	BY	DATE
E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	AD	D3186	SHEET 1 OF 5
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

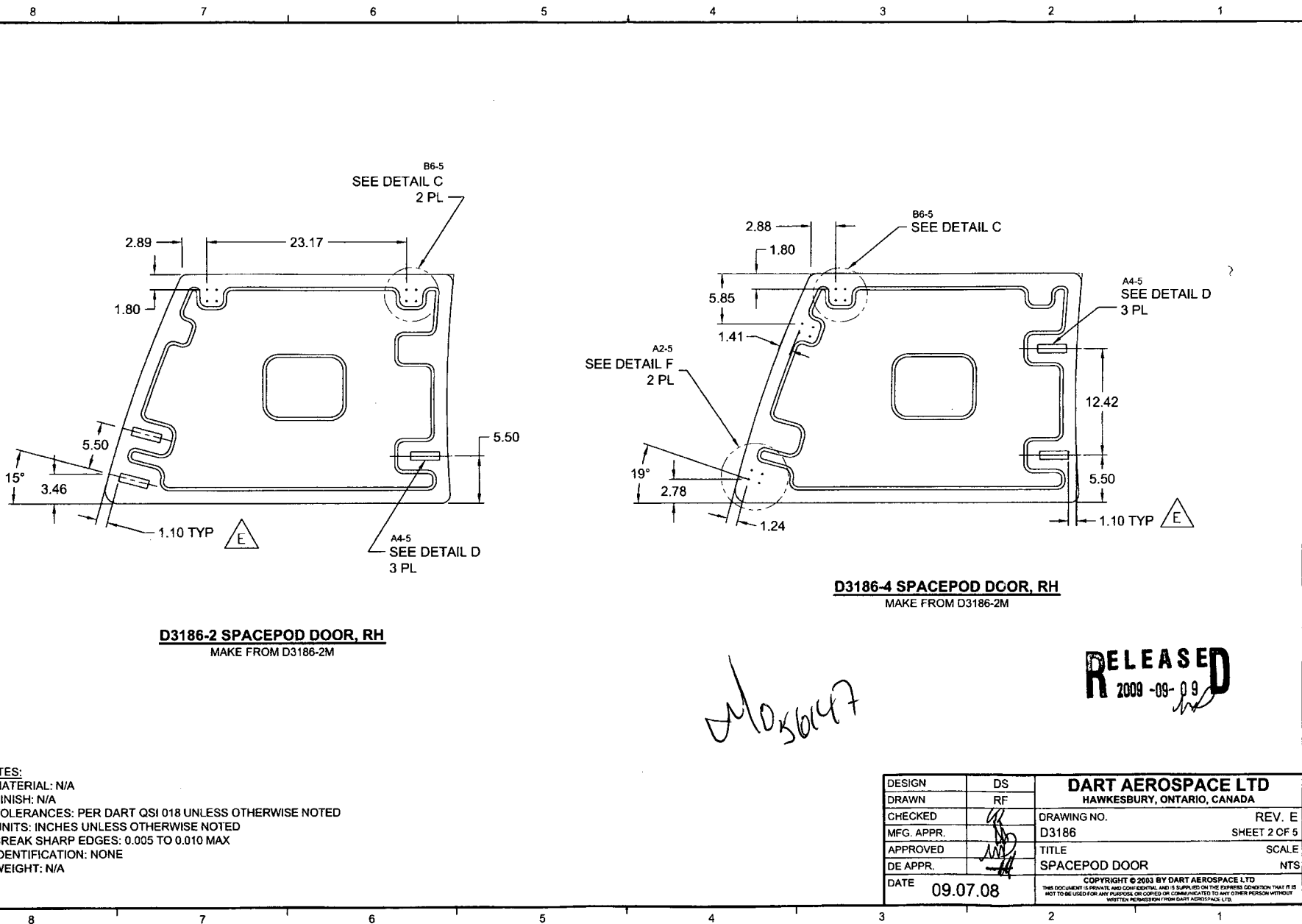
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



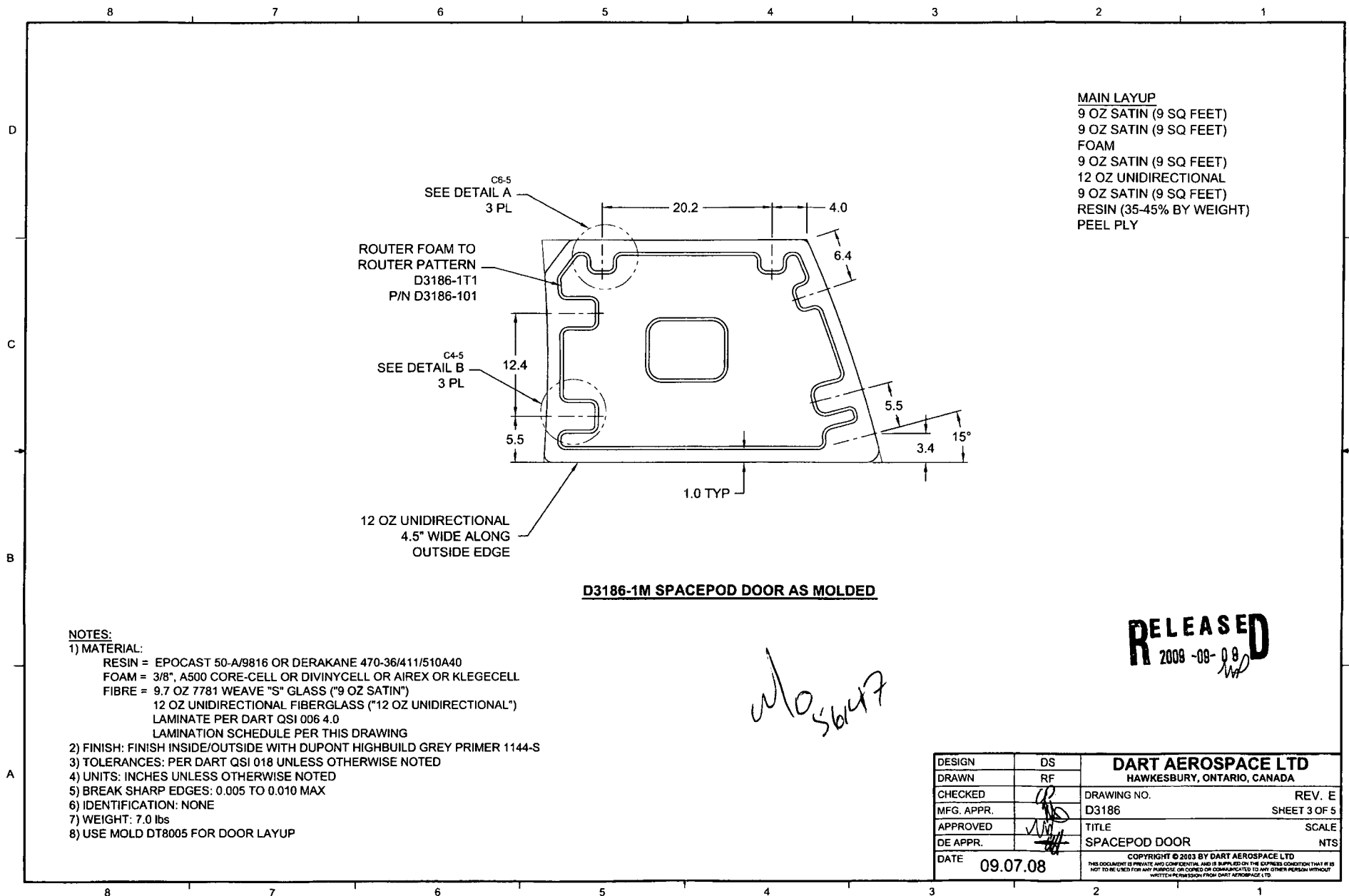
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

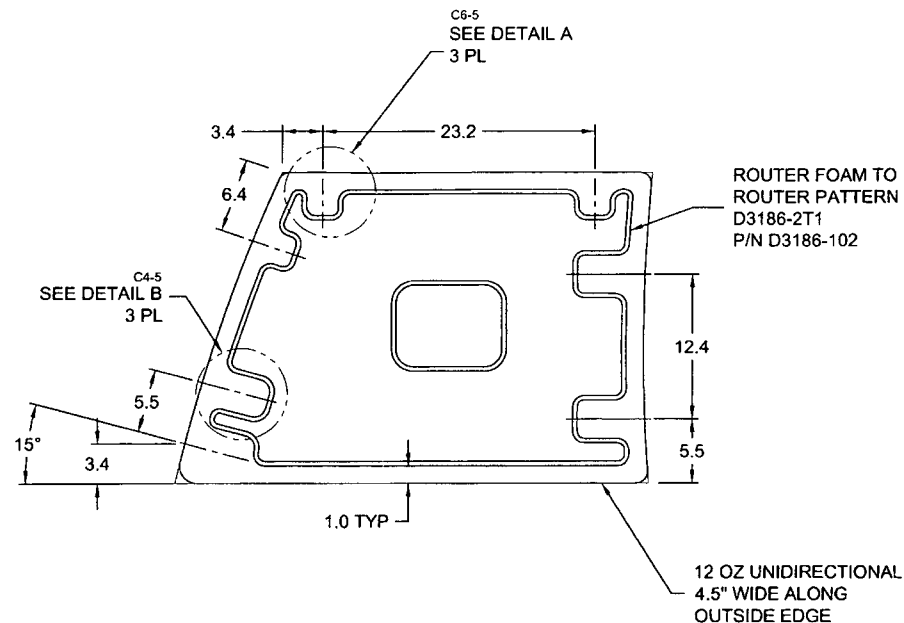
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



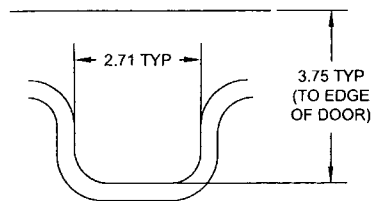
1) MATERIAL:

- RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECCELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 7.0 lbs
 - 8) USE MOLD DT8006 FOR DOOR LAYUP

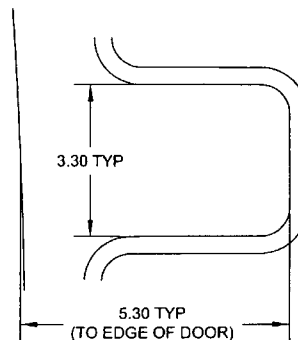
D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED
2009-08-09

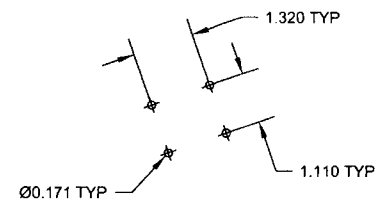
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKSBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NT
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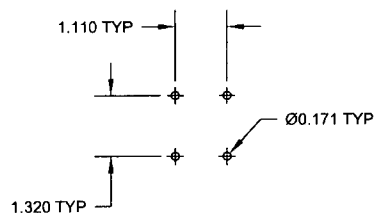
DETAIL A D6-3
SCALE 4X D4-4



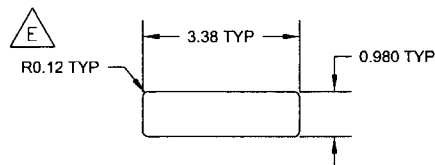
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

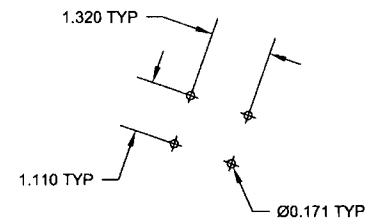


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2






DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR



DETAIL F C4-2
SCALE 4X

RELEASED
2009-09-09

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CHECKED	RF	DRAWING NO.	REV. E
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